

Date: Monday, 12/01/2009 2:37:41 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BASE
Job Number :	44676		
Estimate Number :	13037		
P.O. Number :		Part Number :	D365113
This Issue :	12/01/2009	Drawing Number :	D3651 REV.B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	B
Previous Run :	42117	Material :	
Written By :		Due Date :	06/02/2009
Checked & Approved By :	JUD 09.01.13	Qty:	4
Comment :	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.7140 sf(s)/Unit Total : 2.8560 sf(s)
 304/316 SS sheet 26 ga (0.018" thick)
 Batch: 109398 B95-25

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3651
 Dwg Rev: B B95-25
 Prog Rev: B

2-Deburr if necessary

B95-25

09/05/26 (4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B95-25

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5 02/15/26 (4x)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and stock
 Location 188

9/5/26

(4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:37:41 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 44676

Part Number: D365113

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/27 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mk
09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>H4674</u>
Description: Outside Doubler		Part Number: D3651-13
Inspection Dwg: D3651	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

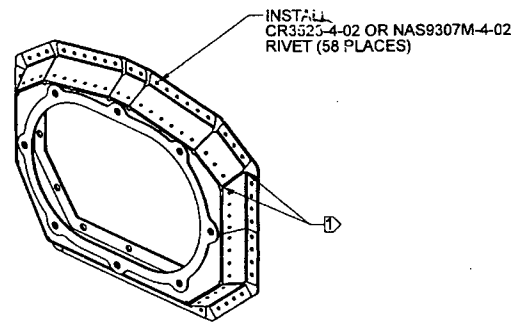
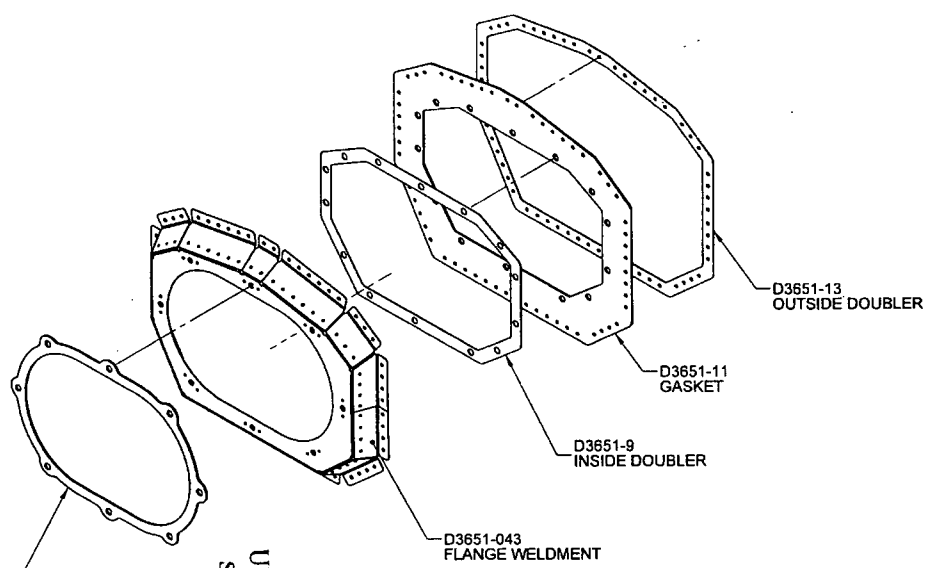
☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.132	X			
0.260	+/-0.010	.260	X			
2.471	+/-0.010	2.473	X			
9.791	+/-0.010	9.794	X			
0.634	+/-0.010	.635	X			
2.564	+/-0.010	2.564	X			
0.52	+/-0.030	.525	X			
0.600	+/-0.010	.601	X			
0.500	+/-0.010	.502	X			
7.969	+/-0.010	7.970	X			
2.348	+/-0.010	2.350	X			
0.480	+/-0.010	.479	X			
5.571	+/-0.010	5.572	X			
0.696	+/-0.010	.699	X			
7.049	+/-0.010	7.049	X			
3.564	+/-0.010	3.562	X			
0.694	+/-0.010	.692	X			
1.779	+/-0.010	1.779	X			
8.74	+/-0.030	8.741	X			

Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>9-5-25</u>	Date: <u>09/05/26</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	<u>[Signature]</u>

8 7 6 5 4 3 2 1



PART LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

WORK ORDER
1441610
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

D3651-041 AFT BASE ASSEMBLY

- D3651-041 NOTES:
- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
 - 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98, REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504		RF	08.01.07
A	NEW ISSUE		RF	07.11.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF	DRAWING NO.	REV. B	
CHECKED	RF	D3651	SHEET 1 OF 9	
MFG. APPR.	RF	TITLE	SCALE	
APPROVED	RF	AFT BASE ASSEMBLY	1:4	
DE APPR.	RF	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	08.01.07			

8 7 6 5 4 3 2 1

